Notebook Series -- Notebooks by Experimenters Other Than Edison
Phonograph Record Experiments
C. T. Dally Disc Blanks Composition Book 2
Notebook, N-18-09-14

This notebook was used by Charles T. Dally during September-October 1918 for numbered experiments on disc blanks. There are also a few separate pages of notes by Edison, along with one note by Edison inserted into the book. The entries describe how each disc performed after being varnished, pressed, printed, or dropped. They frequently indicate numbered "mixes," some of which are identified as "TAE" mixes. The research in this book is representative of the work in the thirteen other books in the group. The front cover is labeled "Disk Records No- 2 Book." The pages are unnumbered. Approximately 120 pages have been used.

No-1

40 Rosin
11.% S. Oil
150. S. Soap
300 Clay
no strength

No-2

60 Rosin
11.% S. Oil
150 S. Soap
300 Clay
no strength

No-3

80 Rosin
11% S. Oil
150 S Soap
300 Clay
Breaks easily with fingers

No-4 100 Rosin
11.% S. Oil
150 S. Drop
300 Clay
Just about break it with fingers
Broke at 2 ft drop on Blotting paper

No-5
120 Rosin
11 % Straw Oil
150 S. Drop
300 Clay
Dried put through 190 mesh
Pressed into blanks
5 min cow at 250 F
3 " Hydro 195 lbs Press
Broke on drop test 2 ft on blotting paper

Pullouts one side

#6

140 Rosin
11. S. Oil
150 S. Hop
300 clay
Dried, fair through 190 heat
5 min cure at 250
5 " High 195 Press } Stuck a little on one side
Broke at 2 ft drop on Blotting paper

7

140 Rosin
11% S. Oil
150 S. Hop
300 clay
5 min cure at 190 F
3 " " " Press 195 lb
Stuck a little on one side

#8

160 Rosin
11% S Oil
150 S. Hop
300 clay
Pressed at 5 min cure at 190 F
3 High " " 195 H Pressure
Pullouts

#9

180 Rosin
11% S. Oil
150 S. Hop
300 clay
Hard to powder it - sticks together

#10

160 Rosin
11% S Oil
150 S Soap
445 chalk
5 min cam at 190 F
3 " Light " 195 Press
Can Break with fingers

#11

160 Rosin
11% S Oil
75 S. Soap
750 Rotten stone A X
5 min cam 190 F
3 " " " 195 Press
No Pullouts
Breaks easily on drop test

#12

160 Rosin
11% S. Oil
75 S Soap
750 Rotten stone AX
5 in com at 200 ft
3 " High " 195 Press
no pullouts
Broke 2 ft drop on Rolling paper

#13

100 Rosin
11% S Oil
100 S Soap
300 clay
Through 190 mesh -
5 in com at 250 ft
3 " High " Press 195 lb
slight pullouts
Broke 2 ft drop on Rolling paper

#14
150 Rosin
11% S. Oil
6% floats
5 min cone 250 F
3 " High " Press 195 - Pullouts stuck
stood drop test on blotting paper
Broke at 11 ft floor drop

#15
160 Rosin
11% S. Oil
75 S. Drop
400 Rotten stones (2 mesh)
5 min cone at 250
3 " High " " 195 lb Press
Broke on first drop on blotting
paper

#16

160 Rosin
11% S. Oil
75 S. Soap
200 Kisselgum
5 min cor at 250 F
3 " Hight " Press 195 lb

No Pullouts
~~Sent~~ broke on blotting paper
Broken at 4 ft drop on floor

#17

160 Rosin
11% S. Oil
75 S. Soap
150 Kisselgum
5 min cor at 250 F
3 " Hight " Press 195
Rosin squeezed out - stuck to mold

#18

160 Room
11% S. Oil
75 S hop
900 Lithophone
5 min cone at 250 F
3 " High " " Press 195
Broke on drop test 2 ft on Blotting paper

#20

150 Room
11% S. Oil
75 S. Drop
6% flock
300 C. Clay
5 min cone at 210 F
3 " High " " Press 195
Small fullouts
OK on Blotting paper drop test
Broke on 2 the drop on floor 4 ft

21

160 Rosin
11% S Oil
75 S. Nap
200 Kissilgar
Dried Put through 190 Mesh
5" Core at 250 ft
3" High " Press 195
No Pull outs
Dropped 8 times on floor before
Breaking

#22
160 Rosin
11% S. Oil
150 S Hop
300 Kieselgur
5 min cure at 250
3 " High " " Press 195
Slight spullerts surface not shiny
Printed at 300 ft
3 min cure [illegible] lbs press
2 " High 220 " "
not full print
drops on first flow drop coat

#23

160 Rosin
6% flock
11% S. Oil
150 S. Hop
250 Kieselguhr

Dried ground in mortar tried to sieve through 60 mesh. flock stays on screen. tried oil from mill in S.

Ground in mortar made blanks without screening

22g pressed at 125 lb. 304 F. temp 307 thick
20g " " 310 " 285 "
18g " " 310 " 247

Varnished & Baked in 24 Bld
Varnish did not soak in, no more bubbles on than there was when varnished
Printed one at 300 F 200 lbs press
varnish cracked some pulled away from blank taking some of Blank with it
Second one stuck to mold pulled all apart

24

160 Rosin
6% flock
11% S. Oil
200 S Soap
250 Kisselguhr

Dried 2 inches from vitreous plate in pipe plate

Looks different from No 23

Looks whiter also looks as if it should have the extra 50 S Soap

Same as No-23 pulled apart

#25
150 Rosin
11% Si Oil
75 S. Nop
3% flock
300 Clay
Pullouts
Varnished and give Rig Baker in 2 w
Pressed 80 lbs at 300°F
Blank squeezed out stuck pulled apart

#26

150 Rosin
11% S. Oil
75 S. Soap
6% flock
300 Clay

#27
150 Rosin
11% S. Oil
75 Soap
9% flock
300 Clay
stuck wn molded
Varnished give Reg Bake
Pressed at 100 lb / 810 R to much
binder stuck - pulled apart

#28

150 Rosin
11% S. Oil
75 S Map
12% flock
300 Clay

#29

120 Rosin
11% S Oil
75 S Nap Mint Squirted
300 clay through 1/32 hole
6% flock

made Blanks 250 F 125 lbs
5 " cow
3 " High, 25 lb Press
1 little pullout on one side
surface somewhat porus. not
ground fine enough
varnished + Baked in 2 " bld
looks like the Var. soaked in
the porus places

Print

2 min cow at 315°
2 " to wash 180 lb Press
8 " at 180 " 325 F
4/5 th of Print was OK but did not get
the pressure. where it is printed it
is a full print
Broke 3 ft on table ~~third~~ drop

#30

100 Rosin
11% Oil
75 Soap
6% flock
300 clay

Mixt squeezed through 1/32 holes

made Blanks
5 Min cow at 300 F
5 " High " 125 Press
Somewhat porus
Would have a shiny surface if ground fine enough
Var. and baked in 2 x Bed
Surface looks rough.
Print
2 Min cow 500
2 " to Reach 330 & 200 lb
5 " at " 200 lb Press
Some of the porus spots showed fine print where it is good
Broke on 2nd drop

#. 31

80 Rosin
11. S Oil
75. S Drop
6% flock
800 clay

mix squeezed through 82 holes

5 min com at 800 F
3 " " " 125 Press
Porus slight Pull out on one side
Var + Baked in 24 Bld
Surface looks rough
Print
2 min com at 300
2 " to reach 330 at 200 lb press
3 " at " " " "
A little hard to extract. Varnish loosened at a couple of places - a few cracks in centers - full print

Varnish cracked more after standing
Broke at first drop

32

60 Rosin
11% S Oil
75 S Hop
6% flock
300 clay
5 min com at 300 F
8 " High " 125 lbs
No Pullouts
Porus
Tor + Printer in 24 Bld
Looks porus
Print
2 min com at 300
2 min to reach 330 at 330 F
Pulled apart when extracted

Broke at first drop

#33 Printed
2 min con at 300
2 " to get to 200 pressure at 310
8 " at " "
Good print no pullouts - except on outer edges I think it sets to deep in mold. Broke on first drop on floor 2 ft

#34 Print
2 min con at 300°
2 " to Reach 125# pressure at 310
8 " at " 200 " "
Good print outside edge breaks off
Broke third drop of floor 2 ft

33
" 29 Mix Powdered put through 30 mesh Screen
Surface not all filled pores
slight pullout on one side
5 Min con at 310 F
3 " High " " Press 125 lb
.248 thick

#34
29 Mix Powdered put through 40 mesh screen
5 Min con at 310°
3 " High " " Press 125
Looks fair not very porus
are very small pull out
253 thick

#35.
Printed
2 Min con at 300°
2 " to reach 150 Press at 310°
8 " at " " "
Full print outer edge pulls out
Broke at third drop 2 ft from
floor dont break dropping 2 from
blotting paper

Printed
2 Min con at 300°
2 " to reach 150 Press at 310
8 " at " "
Full print. outer edge pulls out
Metrics dont fit mold holders
tight enough
dropped four times before breaking
cracked at third drop - 2 ft from
floor dont break dropping 2 ft on blotting paper

#35
29 Min through 60 Mesh
5 Min con at 300°
3 " High " 310. Press 125 lb
Small pullout on one side
slightly porus - can't see it
by eye
.254 thick

#36
29 Min through 60 Mesh
5 Min con at 300
3 " High " 310 Press 125 lb
Pullout on one side

No-37
Printed
2 Min cor at 300
2 to Reach 180 lb Pres 320°
8 min at " "
Squeezed out let mold come together
stuck on one side
P. C
Drop test
2 drops on floor at 5 ft Blow

#38
Printed
2 Min cor at 300°
2 to reach 150 lb Pres 320
8 min at " "
One side of varnish cracked stuck
on edge
Drop test
3 drops on floor at 5 ft Blow

#37
120 Rosin
11.1% S Oil
75 S. Nap
9 flock
300 clay
Rather dry hard to squirt
Squirt through 1/32 hole
the powdered put through 30 mesh
screen

#38
120 Rosin
11.1% S. Oil
75 S. Nap
12 flock
300 clay

#39

Print
2 min cure at 300°
2 " to reach 150 lb at 320
8 " at " "
OK
Drop test
2 drops at 5 ft on floor crope

#39
120 Pod
11.1% S Oil
100 S hop
15% flock
300 clay

#40
2 min cure at 300°
2 " to reach 150 lb 320
8 " at " "
OK
Drop test
2 drops at 5 ft on bare floor crop

#40
120 Pod
11.1% S. Oil
100 S hop
18 flock
300 clay
Slight Pullout

#41

Print
2 min cow at 300°
2 " 6 each 150 lb Press at 320
8 at " "
OK
drop test
10 drops on bare floor at 3 ft
7 " " " 5" 11 - Bottle

#42

Print
2 min cow at 300°
2 " 6 each 150 lb Press at 320
8 " at "
OK
drop test 2 ft drop on blotting paper 11 dr
" 2 " " " bare floor 3
" 5 " " 2 Bot

#41

120 Rosin
11.1% S Oil
115 S Nap
21 Flock
300 clay
No Pullouts

#42

120 Rosin
11.1% S Oil to the Rosin
115 S. Nap = 99 grams
24 flock
300 clay
No Pullouts
No - 37, 38, 39, 40, 41 + 42 Squirt through
1/32" hole the powdered screened through
30 mesh screen

#43

120 Rosin
11.1% S. Oil
150 S. Nap
48% flock
300 clay

Could not acquire it. flock not separated when mixed. Balls up when mixed

#44

120 Rosin
11.1% S Oil
120 S. Nap
48 flock
300 clay

N.G. flock & clays balled up

#45

120 Rosin
11% S Oil
200 S Nap
48 Flock
300 Clay
N.G. Flock stays in balls - dont squirt plugs

No-46

120 Rosin
11% S Oil
115 S Nap
30 Flock
300 Clays
Just about squirt it through 62 hole

#47. 120 Rosin
11.% S.Oil
100, S. Soap
35-% Flock
300 clay

#48 Painted

Con 2 min at 300
2 " to reach 700

Held 8 " at 700 - then cooled
2 small pulloutts
Surface line poorly more

Average thickness .263

253	Weight
262	
273	623 grams
266	
1053	

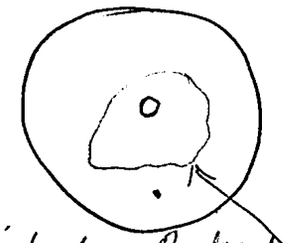
2.37 grams per 1/1000 thick

wanted .200
2.37
444.00 g per Blank

Drop test
10 times at 1 foot
2 " " 2 feet - Broke on last drop

#48

Made a large Record of No 42 Wit
Used 630g in Mold
5 min con at 300°
3 " High 450 lbs 310°
Stuck bad pullout on both sides
most of the pressure on center of
blank



Varnished + Baked in 24 Bld
The part marked in sketch was
covered with large blisters underneath
was cracks and full of pimples
General surface was pimply
on outside edge at two places
varnish was off Blank where it
rested on Rack)

#No-49
120 Rosin
11% S. Oil
115 S. Naph
10 g Lamp Black
300 C. Clay
Mix good Black

No-50
120 Rosin
11% S. Oil
115 S Naph
5 g Lamp Black
300 C Clay
Good Black

#51

444.g used for Blank - through 30 Mu

Calipers - 195
195
199
201
4) 790
197 average

51

Made Large Record/Ns 42 Mry

T.A.E. dont think it was quite dry enough smoked coming out of oven (not burnt)

Blank
5 min cow at 310°
3 " High " 450 lbs press 315
Stuck on Both sides
Edged

Give 1 coat of varnish let dry in air one hr - then put in oven for 1 hr at 110° then 1 hr to reach 150 2 hrs at 150 - then second coat of Var then let stand 1 hr before going in oven then give Reg Bake

Blank Blistered

#52 No. 42 Mix through 20 mesh screen. Large blank
5 min. cor at 310°
3 " High 350 lb press. 310°

No-42 Mix

Put through small Rolls set at 1/8 in 4 Bld one roll hot other hot to prevent mix from sticking

Baked in oven all night at 240 (not Vac oven) shrunk in diam, some

Put two together in Reg Powder Blank molds

Pressed

5 min cor at 305°

3 " High 550 lb Press at 305°

Stuck to plates made a better Blank than by using powder.

average thickness .188

Varnish

Give one coat of var let it dry in air 1 hr. then put in oven for 1 hr at 100 then one hr to reach 130 hold 1 hr at 130 in air

2nd coat let stand 1 hr then Given Reg Bake. Come out OK

Printed

2 min cor at 300°

2 " to reach 800 lb Press 325°

8 " at " " more one side better than other

Surface good a few

#5-4
42 Mt

Blanks made of bob under two pieces of leather
Stood in oven all night at 140
then put in Vac oven for 3 hrs at 85 steam pressure 21 in. Vac
Pressed without heat to 2000 lb
Varnished. Let stand one hr
then put in oven for 1 hr at 110 then 1 hr to reach 130
hold 1 hr at 130
Some small Blisters in blank after first Baking.
Second coat of Var - then Reg Bake - Blisters disappeared on Reg Bake

#55 Dup of 54 Except
after pressing at 2000 lb
repressed 5 min com at 175°
3 " high " 350 press at
175°
First coat Baked - OK

#56

120 Rosin
11 S Oil
115 S Soap
24% flock
400 chalk
N.B.

#57
120 Rosin
11 S Oil
115 Benzol
24% flock
300 clay

No-58
1st coat of Var
1 hr air dry
1 " in oven at 110
1 " to reach 130
1 hr heat " "
and cool

1 hr air dry
thinning, soft
Varnish Blistered
Blank - small raise upon ○
2nd - Big Bape
Varnish Blistered

Painted - Big - scheduled
Surface
after 4 hrs. along Blank blistered

58
120 Rosin
11% Oil
115 Alcohol - Denatured
24% flock
300 Clay
Good Zip
Made Blank on Leather of Gob
dryed in Vac oven - 2 hr in a hot Vac,
Blank was blistered after baking
put in mold give 2000 Pressure looks good

No-59
120 Rosin
11% Oil
50 Shap Small mixer
24% flock
300 chalk

#60

120 Ros
11% S. Oil
50 S Mop
24% flock
300 clay

2 large mixer

#61

120 Ros
11% S Oil
90 S Mop
24% flock
300 clay

#62

120 Roo
11% S. Oil
80. S. Drop
24% flour
300 clay

63

120 Roo
11% S. Oil
50-cc Alcohol
24% flock
300. Clay

64

120 Pour
11% S. Oil
Sol Nap.? (too much)
dont know weather its 50 or 100
24% flock
600 / chalk
Mix was dried on steam plate
all crumbled up some of the lumps
fig no 3/16
Molded
5 cow at 300°
3 high " 450 lb 315°
Surface porous
M.S. Sagged in oven
Bake
Let stand 1 hr in air
1 hr at 110° in oven
1 " to reach 130
Held one hr "

Lot
65
2 Blanks of NO-63 Mix
Pressed between Leather
dried in Vac over - 24" Vac
1 hr without heat
1 " with " no pressure
1 " " 20 lb pressure
1 3/4 " " 40 " "
1/2 " Cool with water
Both blanks warping
Put in oven at 200° for 1 hr
Pressed in cold molds at 2000 psi
1 had a pull out
1 Coat of Varnish
let stand 1 hr in air
put in oven 1 hr at 110
1 hr to reach 130
Hold 1 hr at 150
Then give second coat let stand 1 hr
then give [illegible] bake
Blank slightly Blistered

#66, Blank - No 63 Mineral
Made Blanks in Mold, 1800 lb Press
paper on mold plates (tried in vac. full
1st coat of var & Raisuppo
let dry 1 hr
Then in oven 1 hr at 110°
" 1 hr to reach 130
Hold 1 " at 180
2nd coat var
let dry 1 hr before going to oven
then give mg Rotol
Raisuppo in Blanks not mg more

67

120 Rosin
11% S Oil
25 Alcohol
24% flock
300 Chalk

(90)

68

120 Rosin
11% S. Oil
25 alcohol
24% flock
400 Rottenstone AX

69 ✕
120 Rosin
11% S Oil
25cc alcohol
24% flock
Resorcyam

NB

#70

120 Rosin 27.%
24% flock 5.4%
300 Chalk 67.5%

for Blanks

#70-A T.A.E.
1500 wood fibre
1140 chalk
420 Melted Rosin
all wood fibre in with rosin
after 5 min closed mixing arms
then every 15 min put in 285 chalk
screened through 20 mesh
Var Reg Baked Reg
made 5 Blanks - 2 Blanks looks as if
they only had 1 coat of varnish

#71 TAE Dip

540 Rosin
518 flock
2700 Chalk

Put in all flock + melted Rosin
then every 15 min 900 chalk (not good dip
screened through 1/4 mesh
3 Blanks made of
Reg 2 coats of varnish + Reg Bake
Rough Pipe trifle

#7.2

5-40 Rosin
5-18 flock
27.00 chalk
PN 350 chalk in with melted Rosin
1-5 cleaned
1.15 cleaned
1.25 172 flock in
1.38 " "
2-0 " "
2-20 450 chalk in
2-40 450 " "
3-5 450 " "
3-35 finished
2 Blanks

#73

1/2 of No 72 Batch put through coffee mill
Blemps smooth but can see hard/lee spots. Bad mix

#74

600 Rosin
518 flock
2700 chalk
1350 g chalk all the melted
Rosin
after running 5 min clean
Boddles
Run 15 min more and clean
after running 25 min when mix is
like Dough add 1/2 flock
15 min more add another 1/2 flock
25 " " " " 1/2 flock
20 " " " 450 chalk
20 " " " 450 "
25 " " " 450 "
Then Run 30 min (finished)

75

650 Rosin
518 flock
2700 Chalk

Mixed the same as 74

#76

700 Rosin
5-18 flock
2700 chalk
Mixed the same as No 74

Var Reg No -1841-E

½ Pint = 236 cc contains .94 g Para = 1%
add 2.82 " = 3%
3.76 = 4%

½ Pint = 236 cc contains 7.56 g b/4 = 7.8%
add 2.06 = 2.2%
9.62 = 10%

77 Varnish

½ Pint { add 2.06 g b/4 and 2.82 g Para to 236 cc Reg 1841-E Varnish
4 times as much para = 4% to Pint
" " b/4 = 10%

Dissolved the b/4 + Para in 25 cc alcohol then filtered through linen then added to the Var.

77-A Varnish - For Soft Blanks
5% Para

add 4.12 = 10% b/4
" 7.52 = 5% Para } to 472 Varnish

77-B Varnish = 2% Para
" 10% - b/4
add .94 g Para
2.06 - b/4 } to 236 cc Reg Var

78

Baking schedual

1/2 hr at 110
1/2 to reach 120
3/4 to " 140
1 " 150
Hold 5 hrs 150

No-1 Baking Schedual

#78

70 Blank with No 77 Varnish
Bent over in oven at 150° F when baked
Straightened one on hot mold
Printed 2 min con 125 lbs
10 min at 328
started to squirt out from molds soon as hand on gauge begin to leave pin (2 Resin cooked up through varnish

78.A

No-78
Printing schedual
2 min con at 212
2 " at 190 to reach 750 Pres
Squirt out when pressure reached about 400?

78-B

Sup of No 78 Except different printing schedual
2 min con at 180
12 " High 125 lbs press at 180 to 180
about as high pressure as it will stand / speaker wears

No-79 Mix same as no 70 Except use
clay instead of chalk
960 Rosin =
230.4 flock =
2400 clay =

NG

To dry

#80 - Printing schedual
2 min cond. at 220°
12 " High " 100 Press - 220°
Few small spots not full print
Blank squeezed out about 1 3/4 inch
OK for wear at 20 times
Drop test 53 times one foot high
No-80-A (Printing schedual)
2 min cond. at 200
12 " High " 125 lb Pressure 200° A
Shows wear at 5 times

No-80-B (Printing schedual)

Cond 2 min at 150°
+ " High at 750 pressure 150°
then drop pressure to 75 lbs + raise
temp to 230 for 10 min

#80-C
cond 4 min at 160°
4 min High 750 lb pressure at 160°
then drop pressure to 75 lbs at 230° A
for 10 min Var. Hard - Record crooked
due to being crooked broke on cond — full print

#80-D
Dup of No-80-C Except put a ring between
molds to prevent Record from squeezing out — good full print

#80
70 Blank No-77 Varnish

Baked
1/2 hr at 110
3/4 to reach 120
1 " 130
Hold 7 hrs at 140 } #1 Schedul.

~~#81 #110 Black~~
~~No 77 Varnish~~
~~" 1 Baking Schedual~~

No-1 Painting Schedual

Bring to contact + hold 4 min.
when temp. has reached 160 by
thermometer on platten
Then keeping temp. still 160
Raise pressure to 750 lbs Hyd-
rolic hold for 4 minutes

Then reduce pressure to 75 lbs
Hydrolic + raise temp. to 230 +
hold 10 min - chill

(#70 mix)

120 Rosin — 15 Lbs Steam

28.8 - flock

300 Chalk -

Weight out Chalk in 3 batches. have it all hot.

Put in 1/3rd of Chalk all the flock & all the Rosin,

Mix till perfect then add 1/3 more chalk mix till perfect then add final or last 3rd of Chalk + mix till perfect.

Baking Schedual No-2

1 hr	to reach	110° F
1 "	"	120
1 "	"	125
1½ "	"	130
2 "	"	140

Hold at 140 for 8 hrs

#81

#110 Blank { 1000 Resin = 25.5%
2 40 Cotton = 6. %
2 1100 chalk = 66.9%

No-77 Varnish

11-2 Baking schedual

No-1 Printing schedual

Saged a little when baked temp did reach 145 for five times

Squeezed out 1½ inch when on low pressure at 230 temp I think due to printing was taken from oven after straightening

82

#117 Blank	1000 Rosin	25%
	280 Cotton	7%
	2720 Chalk	68%

No-77 Varnish

" 2 Baking schedual

" 1 Printing "

A little crooked after baking

~~Not fast forward on outside edge~~

~~Burn blank~~

#83 #118 Blank { 1000 Rosin = 25%
320 Cotton = 8%
2680 Chalk = 67% }

No-77 Varnish
" 2 Baking schedual
" 1 Printing schedual
Dont look as if it sagged any
Not a full print on out side edge
Burn Blank

H

84

D 119 Blank { 1000 Rosin = 25%
360 Cotton = 9%
2640 chalk = 66%

No 77 Varnish
" 2 Baking schedual
" 1 Printing schedual
Did not say any when baked
not a full print. Bad blank
Wear test 100 times OK
" 200 " shows a little wear

#85

#70 Blank Pressed in a Reg
Powder Blank mold
5 min cor at 180° F
3 " High at 750 lb press at 180° F
Pullouts on both sides (smooth surface
Smooth surface after baking no blisters or
bubbles
No 77 Varnish
" 2 Base schedule
" 1 Print "

#86

No-70 Blank pressed in Reg Powder
Blank mold
5 min cow at 165
3 " High 750 lb press at 165
Pullouts on both sides not bad as
No-85 (smoth surface
not quite as good as No 85

#
87

No 70 Blanks put in oven without
Varnish Baked at No-2 schedual
then ~~strawtained~~
No-77 Varnish
" 2 Baken schedual
" 1 Prints " "

Sep 14-18

#88

D122 Blanks { 1200 Rosin 30%
400 Cotton 10%
2400 chalk 60% }

← worst sayed when Baked

No. D122, D123, D124, D125 and D126 Blanks where varnished with varnish that was in icebox before it had 3 days it looked thicker than when it was fresh

extra 6% + Para

No. 77 Varnish
" 2 Baking schedual

#89

#123 Blanks { 1280 Rosin = 32 %
480 Cotton = 12 "
2240 Chalk = 56 "

No-77 Varnish
" 2 Baking schedual
Printing schedual
4 min com, at 180°
4 " High 750 lbs at 180°
10 " 75 lb pres at 230°
One side full of Pullouts
Other side no pullouts - only a few spots not full print
Blank squeezed out 1/2 inches when printed

#90

#124 Blanks { 1400 Rosin - 35%
600 Cotton = 15%
2000 Chalk = 50%

No-77 Varnish
" 2 Bake schedual

#91

~~6~~ 125 Blank

1320 Rosin = 33 %
600 cotton = 15 "
2080 chalk = 52 "

No 77 Varnish
" 2 Baking schedual
" 1 Printing schedual except
High pressure 925 lbs

#92

~~4~~-126 Blanks 1080 Rosin = 27%
320 Cotton = 8"
2600 Chalk = 65"

~~No-77 Varnish~~
~~" 2 Baking~~ Schedule
No-77 Varnish
" 2 Baking schedule
" 1 Printing schedule
not full prints

93

126 Blanks

#77 Varnished then put in Vac. for 2 min. at 20 inches of mercury then let stand 15 min. before second coat, then 2 min in Vac 20" mercury
Then Baked No 2 schedual

No - 2 Bake schedual

Printing schedual

4 Min. Con at 180°
2 " High 750 lbs at 180
10 " 75 lbs press at 230

#3 Bake Schedual
for Soft blanks
using 5% Para

1 hr to reach 110
1 " " 120
1 " " 125
1 " " 130
Hold 8 hrs at 130

#94 No 70 Mix for Blanks
Made with CO_2 gas going
in mixer when made also
when heat in oven

94 A

No-70 Blanks made in Mixer
with CO_2 then put in oven
without gas - proved

95

138 Lead Decorator
28.8 flock
300 chalk

N G

96.
~~A~~ 126 Blair
No-77 Varnish
" 2 Base
Printing Schedual
4 hr cor 160°
2 " High 925 lbs 180°
then 10 min at 230° - 75 lb press

#99
Not full print.
Stuck on one side
Varnish not cured - can mark it
with fingernail

#97 - Blank
1200 Rosin
230 flock
2400 clay
not quite enough Rosin to dry

#98
1320 Rosin - 165 [illegible]
230 flock
2400 clay
Just about [illegible]
cold

#99
1420 Rosin = 177.5
230 flock
2400 clay
Got all the gobs out
No-77-A Varnish
" 3 Bake
Pump schedual
4 min at 180°
2 High 750 lb press at 180°
10 at 75 lb press at 230°

#
99-A Dup of no 99 except forming cylinder

4 min cow at 210°

2 " High " 750 lb at 210°

10 " 75 lb press at 230°

Varnish not cured. Stuck on both sides

Not full print. Squeezed out about 2½ inches

100

~~[illegible]~~

#100 Mix for Blanks

12 Bitsomite

5 Manjak

10 Rosin

CIGJ

No-101
Rimpeled - cracked
Blank cracked - Pullouts
Printed
Oct 4

Inspected
Nov 13

101

No-100 mix 177.5g — 35%
28.8 flock — 5.6%
300 clay — 59%

1 coat of Varnish with [illegible] 10% [illegible]
Give Reg. Bake in [illegible] Oil.
Reg Printing [illegible] - Very little [illegible] down
did not stick to mold but hard to
get out of mold [illegible] rings to make
mold deeper
Cracked making [illegible]

102

Rimpeled Blank cracked
Printed
Oct. 5

Inspected
Nov 13

102

No-100 mix 165g 33.3
28.8 flock 5.3
300 clay 60.

Made into [illegible] let it cool until
cool then [illegible]
could not get it hot enough to press
To a disk only pressed [illegible] way
- Rip it but [illegible] it [illegible] to the
press - come out OK
Give one coat of varnish - Baked in [illegible] Old
Reg oven [illegible]
[illegible] gauged out out 1/2 inch good full print
stuck on one side. [illegible]
[illegible] mold

#103

150 No-100 mesh
2618 flock
300 clay

Loaf's as of this mix is about [illegible] No-100 [illegible]

#
104

No - 98 Blank with one coat of
Varnish 2 j. Resin 10 % - 6/4
not Baked. cured in press
Printing schedual
4 min Cure at 180
2 " High 750 lb 180 [illegible] 2"
10 " 750 lb pressure at 180
Had to [illegible]
stuck bad

No - 105

No - 98 Blank with 1 coat of
Reg Varnish - not Baked cured in
press

#106

No-99 Blank with 1 coat of Varnish 2% fenol 10% - 6 - not Baked cured in press

#107 No-99 Blank with 1 coat of Reg. Varnish not Baked cured in press

#108
#94 Blank 1 coat of varnish with 2% para 10% oil not baked cured in press

#109
#94 Blank 1 coat of Poly Vac. not baked - cured in press

110

#10 Blank
1 coat of Var 2% Para - 10% 6/4
not Baked Cured in press
[illegible] not Blank 105, 106, 107, 108 [illegible]
110 Dist [illegible] 1864

111

[illegible]
77-A Varnish
N-3 Bake
Printing scheduled
4 min Pat 180°
2 " High 750 lb 180°
10 " 750 lb press at 250°
Stock [illegible]

C 75

#113 - Rinkeled & cracked in center
Pullouts - Printed Oct 7 - Inspected Nov 13

#113
Pressed - got press at 124° had 2 small pullouts

#113-R
Dup of 113-B
Bad pullouts Part of Blanks come with it Printed Oct 14 Inspected Nov 13

113-A Rinkeled - Record cracked
Printed Oct 9 Inspected Nov-13

#112
1309 No 100 mix
28 lb block
500 clay

#113
259 lb Disonite 37%
2 block 6 - 10.6% to the Gilsonite
399 clay 57
1 coat of Reg Varnish - Reg Bake in 24 Bld
Printed [illegible]

113-A
Dup of 113 Except 2 coats of Varnish
Printed Reg 115 lbs steam 220° F
Blank Pressed out between molds about 2" on one side - Extracted from mold fine
Slightly Rinkeled - Bad P. O

#114
2 Blanks No-101 with 1 coat of Reg Varnish - Baked in 24 Bed

#115 Printed Oct 7 Inspected Nov 13

#115 Rinkled - Pullouts - 3 cracks in Center - Printed Oct 9 - Inspected Nov 3

#115B Rinkled Pullouts -

#115-B
Dup of 115-A Except High pressure when printing was 400 lb - Squirt out just as much as 800 lb pressure
Not as good a print as No-115-A.
Bad pullouts on both sides

115-A Rinkled - 3 cracks in Center
Printed Oct 9. Inspected Nov 13

#115
4 No 101 Blanks with 2 coats of Reg Varnish - Baked in 24 Bed
Printing [illegible]
[illegible] 9 lb
steam 300° F
Bad pullouts on both sides
115-A Dup of No 115 Except had 118 lb steam 220° F - Squeezed out about 1½ inches between molds - Print OK

#116

270 Gilsonite 1/3 distilled 38.5%
42 g flock 6%
378 clay 54%

to dry

#117

300 Gilsonite 1/3 distilled 47.3%
42 flock
378 clay

Very stiff mix could not make a ball of it put in press — about 4 lumps pressed good except at one spot on outside edge - Looks as if can't pick it hot enough although hot as steam will make it

Pressed in gob press at 126 "O.K."

#118 Very Bodly Rimpled
Blank cracked 5 places

Printed	Inspected
Oct 9.	Nov 13

#119
Very Bodly rimpled
Record cracked 4 places

Printed	Inspected
Oct 7	Nov 13

#118

325	Gilsonite ⅓ distilled	= 46.9%
42	flock	6. %
325	clay	46.9%

2 coats of Reg Varnish Varnished & Baked in 24 Bed
Surface looks granular after Baking
Reg Printing schedual. 120 lbs steam
326° F. Squirted out 2 inches (very thin)
Record cracked in 8 different places
Fine full print

#119

420	Gilsonite ⅓ distilled	60%
70	flock	10
210	clay	30%

2 coats of Reg. Varnish Baked Reg in 24 Bed
Surface looks granular after Baking
Reg Printing schedual 120 lbs steam
326° F. Squirt out 2 inches. Very thin
Record cracked for places
Fine full print

#120

Very Badly rimpled
Record cracked 4 places
Printed Inspected
Oct. 9 Nov-13

No-121
Rimples all over not cracked
Printed Inspected
Oct 14 Nov 13

Oct-9-14

#
120
490 Gilsonite 1/3 distilled 70 %
105 Cotton flock 15 "
105 Clay 15
Weight of Blank 325 g
2 Coats of Reg Varnish Reg Bake in 24 Bld
Reg. Printing schedual 120 lb steam 326° F
Squirt out 2 inches bottom molds - very thin
Cracked
Fine full print

No-121
260 Gilsonite 35.3
75 flock 10% — 22.3% to the Gilsonite
400 Clay 54.4
2 coats Reg Varnish + Reg Bake in 24 Bld
Reg Printing schedual 320°F
One pullout in center of Record
OK print

C185]

#
122

Ripples all over not cracked
Printed Oct 14 — Inspected Nov 13

123 - Ripples all over not cracked
Inspected Nov 13 — Printed Oct 14

#122

260 Gilsonite - 33.5%
115 flock 14.9% - 30.7% to the Gilsonite
400 clay 51.6%
Mix stiff wont stand any more flock
2 coats Reg Varnish + Reg Bake in 24 Bld
no pullouts - Reg Printing schedual
flowed 1/2 inches when printed
OK print

#123

260 Gilsonite 36.8%
145 flock 20.5% - 35.8% to the Gilsonite
300 clay 42.5%
2 coats Reg Varnish + Baked in 24 Bld
Reg Printing schedual - 12 min
No pullouts - flowed 1/2 inches when pressed
OK print

124

Ripples all over not cracked
Printed Cat 1.4
I inspected 2-20-13

#
124

260 Gilsonite 34.8%
185 Flock 24.8% = 41% to the Gilsonite
300 clay 40. %

Very stiff. Wont stand any more flock or clay - Temp of press to press blank 137°F
2 coats Reg Varnish
Reg Bake in 24 Bld -
" Printing schedual 12 min
No pullouts - flowed about 1/2 when pressed
OK print

#125

259 Coal tar pit distilled 37%
42 flock 6% - 10.6% to the tar
399 clay - 57%

To dry

#126

300 Coal tar 1/4 distilled off
352 clay
to much clay made it dry
not enough to make a flash
~~Cracked in 3 pieces drilling center hole~~

#127

600 Coal tar 1/4 distilled
600 Clay
all the clay it will stand
cracked in three pieces drilling center
hole

#128
Scarcely any Pimples
Blank cracked
Printed Oct 16 — Inspected Nov 13

129
no Pimples cracked several places
Printed Oct 16 — Inspected Nov 13

#128
600 Coal Tar ¼ distilled 80.1%
150 Flock — 20%
2 Coats of Reg Varnish + Reg. Bake in 24 Bld.
Reg Printing schedual - 324° F
Full print - Flowed out between molds 2 inches
Cracked in four places

#129
600 Coal tar ¼ distilled 59.1%
100 flock — 9.8
315 clay 31.
2 Coats Reg, Varnish + Baked in 24 Bld
Reg Printing schedual - 324° F
Full print flowed between molds 2 inches
Full of crack - not Varnish - Record

#130

No Ripples Blank cracked
Printed Inspected
Oct 16 Nov 13

#131

Badly Rumpled - Pullout Bad
Printed Inspected
Oct 18 Nov 13

#130

600 Coal tar 1/4 distilled
65 flock — 57.9%
450 clay
2 coats Reg Varnish + Baked in 24 Bld
Reg Printing schedual - 320° F
Full print flowed about 1 inch between ~~plate~~ molds
Record full of cracks

#131

250 Gilsonite — 33.3%
100 Wood flower 13.3%
400 clay 53.3
2 Coats Reg. Varnish + Reg Baked in 24 Bld.
Reg Printing schedual - 320° F
Full print flowed about 1 1/2 inches between molds

#132

Bodly Rippled - small P.O.
small crack on margin

Printed Oct 18 | Inspected Nov 13

133

Bodly Rippled. No cracked
Printed Oct 18 | Inspected Nov 13

Oct 16-18

#132
250 Gilsonite 35.7 %
200 Wood flour 28.5 %
250 Clay 35.7 %
2 coats of Reg. varnish & Reg Baker in 2 4 Bld
full print flowed 1½ inches when printed
Reg Printing Schedule 320°

#133
250 Gilsonite 30.3 %
50 Wood flour 6. %
525 Clay 63.5
2 coats Reg. varnish & Reg Baker in 2 4 Bld
full print flowed 1½ inches when printed
Reg Printing schedule 320°

[ITEM(S) FOUND IN BOOK]

Schedul #2

1	Hour to reach	110°	Fahr
1	" "	120°	"
1	" "	125	"
1½	" "	130	
2	" "	140	

Hold at 140 for 8 hours.

[ITEM(S) FOUND IN BOOK]

175	35%
30	6%
[redacted]	
295	59%
500	

155	31%
30	6%
315	63%
500	

[ITEM(S) FOUND IN BOOK]

% Gilsonite to the total mix	% Flock to the total mix	% Flock to the Gilsonite	% Clay to the total mix
No-113- 37%	6%	10.6%	57%
" -121- 35.3%	10%	22.3%	54.4%
" -122- 33.5%	14.9%	30.7%	51.6%
" -123- 36.%	20.5%	35.8%	42.%
" -124- 34.8%	24.8%	41.%	40.